

Date: Monday, 13/04/2009 8:22:42 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 47123		
Estimate Number	: 13066		
P.O. Number	:	Part Number	: D36811
This Issue	: 13/04/2009 S.O. No. :	Drawing Number	: D3681 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 46107	Material	:
Written By	:	Due Date	: 22/04/2009 Qty: 40 Um: Each
Checked & Approved By	: <u>JUD 09.04.13</u>		
Comment	: Est Rev A new issue 07-10-30 DD verified by: Est Rev:B Ecn 1056 Rev A dwg DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T03125W058	ALUM TUBE .3125 x .058w
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Comment: Qty.: 0.3570 f(s)/Unit Total: 14.2800 f(s)

Material:

(M6061T6T0.313W.058)

Batch: M110532

9.961'

09/04/14

2.0	HARDINGE <u>DOOSAN</u>	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA7118 DWG D3681

FOLIO REV: N/ADWG REV: A

2-DEBURR AS REQUIRED

09/04/14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/04/14 (28)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09/04/14 (28)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Barkley

09/04/14 (28)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 13/04/2009 8:22:42 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 47123

Part Number: D36811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/14 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



in 09.04.14

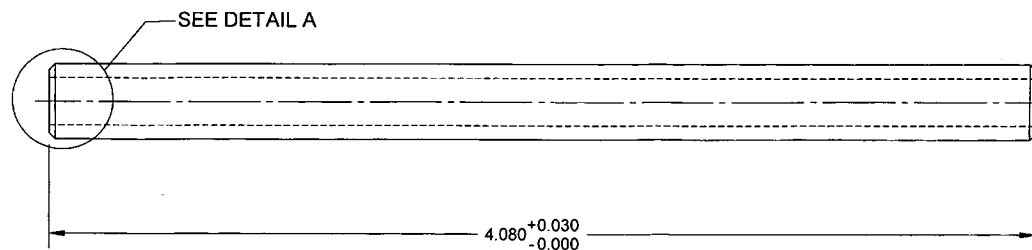
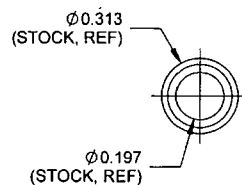
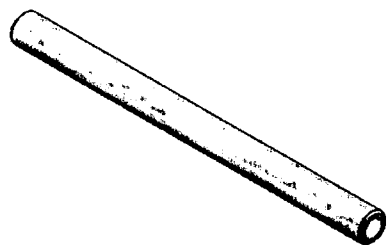
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

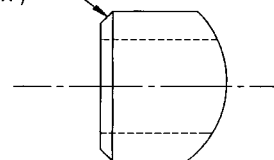
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

D3681-1 SPACER

NO. 11-01-01
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
07-11-08

A NEW ISSUE		DC	07.11.08
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	MS	DRAWING NO.	REV. A
MFG. APPR.	EP	D3681	SHEET 1 OF 1
APPROVED	W	TITLE	SCALE
DE APPR.	H	SPACER	2:1
DATE	07.11.08	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	